

Date: Monday, 7/30/2007 1:46:02 PM
 User: Kim Johnston

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : RESTRICTOR FITTING |
| Job Number : 33766 | |
| Estimate Number : 10928 | |
| P.O. Number : <i>N/A</i> | Part Number : D2005013 |
| This Issue : 7/30/2007 S.O. No. : <i>N/A</i> | Drawing Number : D2005 REV C |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : <i>N/A</i> Type : SMALL / MED FAB | Drawing Revision : C |
| Previous Run : 28208 | Material : <i>N/A</i> |
| Written By : <i>[Signature]</i> | Due Date : 8/6/2007 Qty: <i>5</i> Um: Each |
| Checked & Approved By : <i>[Signature]</i> 07.07.30 | |
| Comment : Est. B 99.08.24 Re-format DM/EC | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|---------|-------------------------|
| 1.0 | AN8328J | Union, Bulkhead-M-Flare |
|-----|---------|-------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Elbow, Bulkhead-M-Flare

Pick:

| | | | |
|-----|-------------|-------------|-------------|
| Qty | Part Number | Description | Batch |
| 1 | AN832-8J | fitting | M 01925 (4) |

SB 07/08/22 (4)

| | | |
|-----|----------|------------|
| 2.0 | D2005003 | Restrictor |
|-----|----------|------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Restrictor

Pick:

| | | | |
|-----|-------------|-------------|---------|
| Qty | Part Number | Description | Batch |
| 1 | D2005-003 | Restrictor | B 19073 |

SB 07/08/22 (4)

| | | |
|-----|-------------|-------------------------------|
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL / MED FAB

Machine elbow P/N: AN833-8J per Dwg. D2005-013

Press fit D2005-003 restrictor in place as per Dwg. D2005-013

Note: (15° chamfer towards inside of fitting)

Stake restrictor in place using clean ballpeenhammer to tap down edge.

Polish smooth finish

Scribe P/N: D2005-013

SB 07-08-22

MF 07-08-22

| | | |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

SB 07/08/22 (4)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: LD Date: 07/08/23
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RESTRICTOR FITTING

Job Number: 33766

Part Number: D2005013

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/8/23 50

(4x)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(4)
7/8/23

Job Completion



U 7-8-23

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

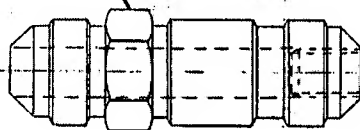
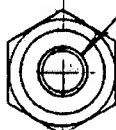
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | |
|-------------------------------|--------------------------------|--|----------|
| DESIGN BRADLEY | DRAWN BY BRADLEY | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2005-013 | REV C |
| DATE 96.04.17 | | TITLE RESTRICTOR B'HEAD FIT'S | SCALE |
| C | | REDRAWN 96.04.17 BRADLEY <i>[Signature]</i> | |

RELEASED
47/09/03 DSAN 832 - 8J
FITTINGDRILL 11mm DIA
X.500 AS SHOWND 2005-003
FORCE FIT AS
SHOWN AND STAKE
IN PLACE.DETAIL OF D2005-013SCALE 1:1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33766